

1. A method for manufacturing a release-controlled pipe which mainly comprises a plurality of steps which are:

5 Mixing Formulation: a plurality of elastomer pellets and a binder being mixed to said formulation, wherein said elastomer pellets occupy 60 to 80 percent and can be rubber material such as waste tires which said binder occupies 40 to 20 percent and can be resin material;

First Hot Melt Extrusion and Cooling: said formulation being poured into a first melt extruder to form a rod-like extrudate, and then said rod-like extrudate being cooled through a conveyor and a cooling unit;

Grinding and Blending: said rod-like extrudate being ground into pieces, then being placed into a water-filled container and dry container for collecting separately;

20 Second Hot Melt Extrusion: a mixture of dry ground pellets and wet ground pellets soaked in water, with a small amount of lubricant such as steric acid, being poured into a secondary hot-melt extruder and a pipe die head being used for shaping a release-controlled pipe;

Cooling: said release-controlled pipe extruded by means of said pipe die head being cooled and having a fixed shape through a water tank and a sprayer, and then being gathered by a winder.

2. A method for manufacturing a release-controlled pipe as recited in claim 1, wherein said ground pellets are soaked in said water-filled container for more than one day to get enough water content.